



Dart Aerospace Ltd.
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Canada

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D4272-011
Job Sheet 183240



Part No: D4272-011

Job Qty: 1 ea

Part Name: Basket Assembly, Heavy Duty Lid, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/14/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:A 11.01.20 AS PER DWG REV.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/28/18	9/28/18	0.00	0.00	Start Up Stores/Pkg-1		HL 18-10-26
100	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging1-5		HL 18-10-26
110	HandFinish	1 pcs	9/28/18	9/28/18	0.00	2.94	HandFinish4		HL 18-10-26
120	QC	1 pcs	9/28/18	9/28/18	0.00	0.00	QC5	DAS	OCT 26 2018 68
130	Packaging	1 pcs	9/28/18	9/28/18	0.00	0.00	Packaging3-2	69	9-89
140	QC21-SA	1 Ea	9/28/18	9/28/18	0.00	0.00	QC21	9-89	OCT 26 2018

Part Op 110 - TRANSFER DRILL FROM PLACARD INTO BASKET AS PER DWG ON SHEET 2 RIVET PLACARD AS PER DWG
Descriptions: ON SHEET 2

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97447A010	Blind Rivet	4 pcs (4 ea)	90-Start up Operation	5019014
AN3-10A	Bolt	3 Ea (3 ea)	90-Start up Operation	5089298
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068652
AN3-16A	Bolt	2 Ea (2 ea)	90-Start up Operation	5089276
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5082901
AN310C4	Nut	3 Ea (3 ea)	90-Start up Operation	5065269
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	* 5074206-1
AN4-13A	Bolt	6 Ea (6 ea)	90-Start up Operation	5089302
AN4C15	BOLT	1 Ea (1 ea)	90-Start up Operation	5053946
AN5-17A	Bolt	4 Ea (4 ea)	90-Start up Operation	5068640
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5109659
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5073832
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5115452
D2690-6	Lanyard	2 Ea (2 ea)	90-Start up Operation	5107909
D2931	Bumper	2 Ea (2 ea)	90-Start up Operation	F86435
D3912-041	Eyebolt Receiver Assembly	1 Ea (1 ea)	90-Start up Operation	* 5118806
D3914-041	Long Basket Lid Assembly (350)	1 Ea (1 ea)	90-Start up Operation	5111825
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5115446
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	* 5119290
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5068381
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5068380
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	* 5117579

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5115821
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5115399
D3969-3	Spring (Basket Lid)	1 Ea (1 ea)	90-Start up Operation	5107870
D4021-5	Blanking Plate	1 Ea (1 ea)	90-Start up Operation	5072829
D4150-041	Attachment Arm Assembly	1 Ea (1 ea)	90-Start up Operation	5091366
D4151-041	Basket Fwd Hardpoint Assembly, Lower	1 Ea (1 ea)	90-Start up Operation	5104909
D4151-043	Basket Fwd Hardpoint Assembly, Upper	1 Ea (1 ea)	90-Start up Operation	X 5127785
D4273-041	Basket Base Assembly, LH	1 Ea (1 ea)	90-Start up Operation	511287
D4307-250	Placard, Max Load	1 Ea (1 ea)	90-Start up Operation	X 5022292
MS17984-C413	Quick Release Pin	2 pcs (2 ea)	90-Start up Operation	5109954XL
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	90-Start up Operation	5076007
MS21042L3	Nut	9 Ea (9 ea)	90-Start up Operation	5094592-1
MS21042L4	Nut	6 Ea (6 ea)	90-Start up Operation	506789
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5083541
MS24665-151	Cotter Pin	4 Ea (4 ea)	90-Start up Operation	5053951-1
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5104465
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5050052-1
NAS1149C0463R	Washer	3 Ea (3 ea)	90-Start up Operation	FM127206-15
NAS1149DN832J	Washer	2 Ea (2 ea)	90-Start up Operation	5034411
NAS1149F0332P	Washer	14 Ea (14 ea)	90-Start up Operation	5103666-1
NAS1149F0432P	Washer	18 Ea (18 ea)	90-Start up Operation	5083508-1
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	5067901-2
NAS1515H4L	Washer	2 Ea (2 ea)	90-Start up Operation	5044189

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97447A010	4	714	0
	AN3-10A	3	301	0
	AN3-14A	4	100	0
	AN3-16A	2	118	0
	AN310-4	3	115	0
	AN310C4	3	143	0
	AN4-12	3	73	0
	AN4-13A	6	924	0
	AN4C15	1	19	0
	AN5-17A	4	102	0
	D2530	1	18	0
	D2535	2	54	0
	D2537	2	12	0
	D2690-6	2	39	0
	D2931	2	958	0
	D3912-041	1	6	0
	D3914-041	1	2	0
	D3917-3	6	21	0
	D3953-17	2	21	0
	D3953-19	1	26	0
	D3953-21	1	10	0
	D3953-3	2	4	0
	D3953-7	2	20	0
	D3953-9	2	7	0
	D3969-3	1	18	0
	D4021-5	1	46	0
	D4150-041	1	7	0
	D4151-041	1	6	0
	D4151-043	1	3	0
	D4273-041	1	0	0
	D4307-250	1	4	0
	MS17984-C413	2	46	0
	MS20600-AD4W3	2	357	0
	MS21042L3	9	3,308	0
	MS21042L4	6	4,202	0
	MS21042L5	4	888	0
	MS24665-151	4	252	0
	MS24665-300	2	128	0
	NAS1149C0432R	2	2,781	0
	NAS1149C0463R	3	335	0
	NAS1149DN832J	2	1,313	0
	NAS1149F0332P	14	3,621	0

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 Canada
 TEL: 905 813 632 - 5200
 Email: sales@dartaero.com
 www.dartaerospace.com
 Part: D4272-011
 Job No: 183240
 Serial No/Batch: S121885
 Revision:
 Inspector:
 Exp Date:
 Instructions: Various STC's
 Date: 10/26/18

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

NAS1149F0432P	18	1,559	0
NAS1149F0563P	4	966	0
NAS1515H4L	2	263	0

Part Specifications

Specifications could not be found.

Plex 9/14/18 7:27 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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		OTHER : ☐			